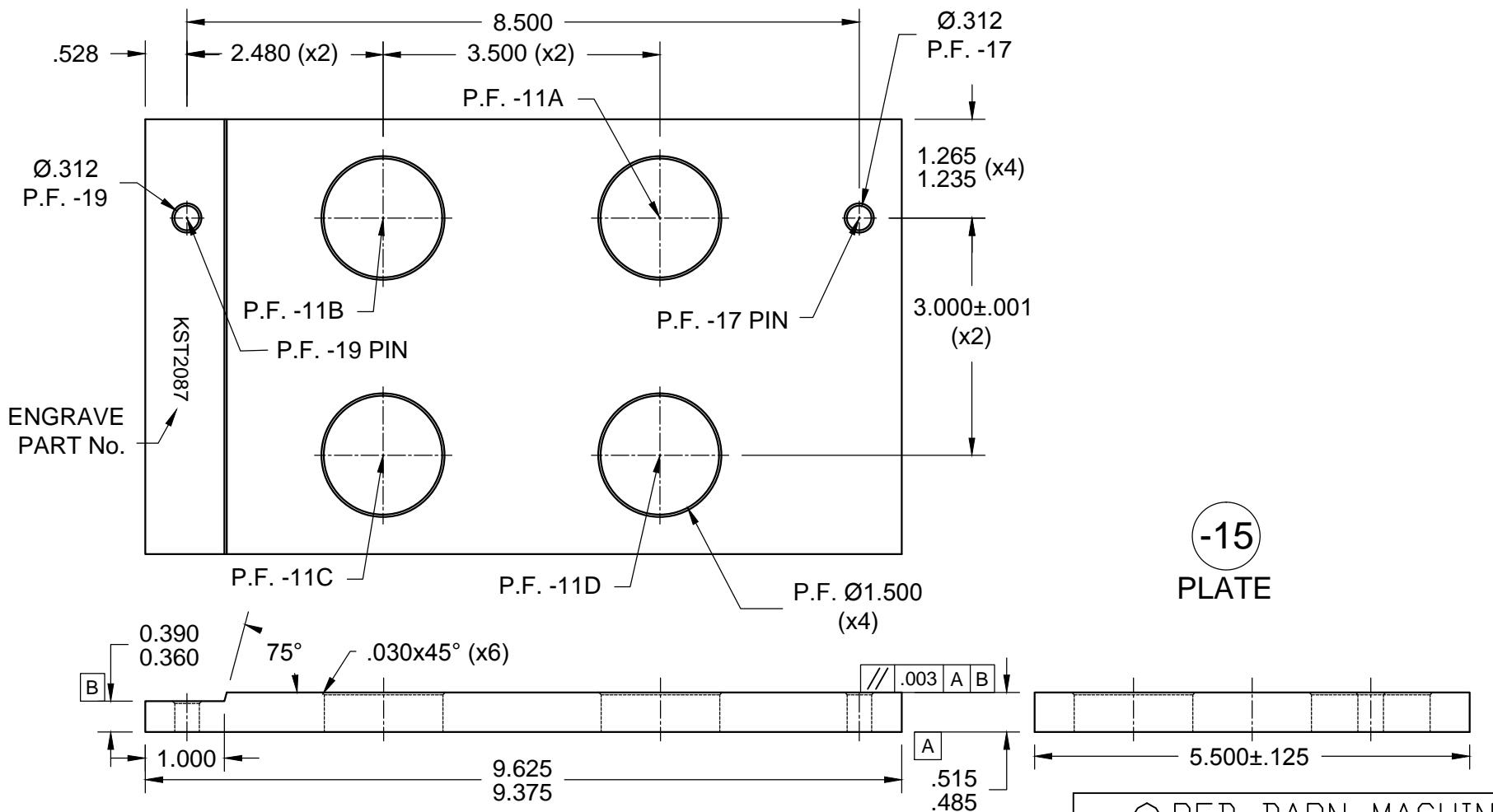


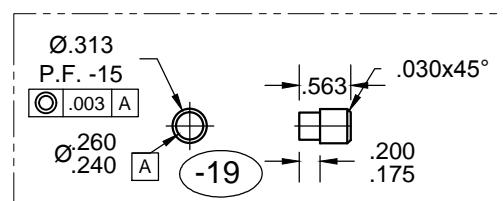
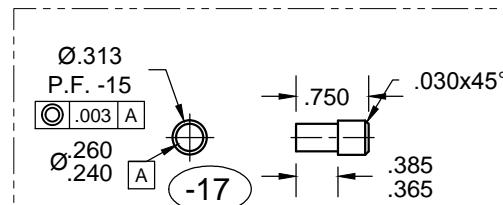
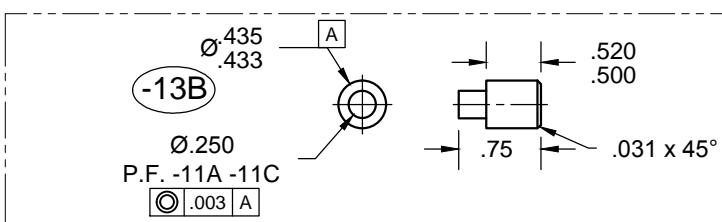
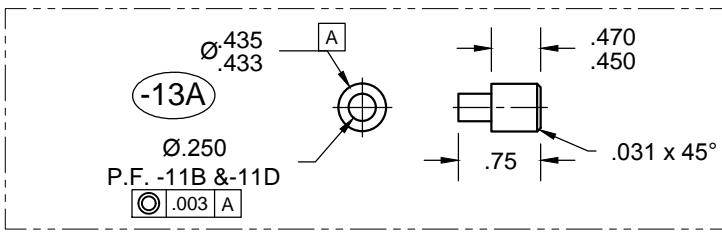
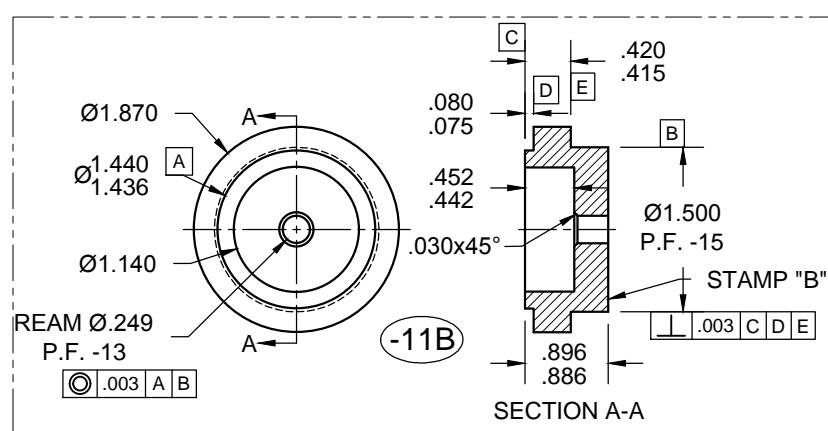
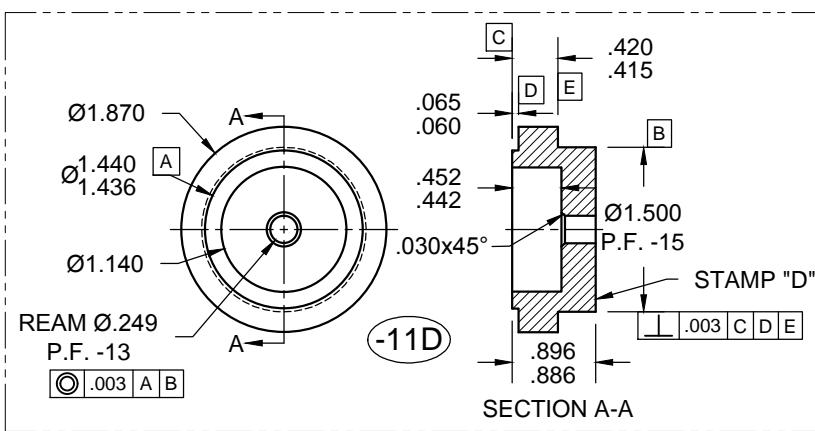
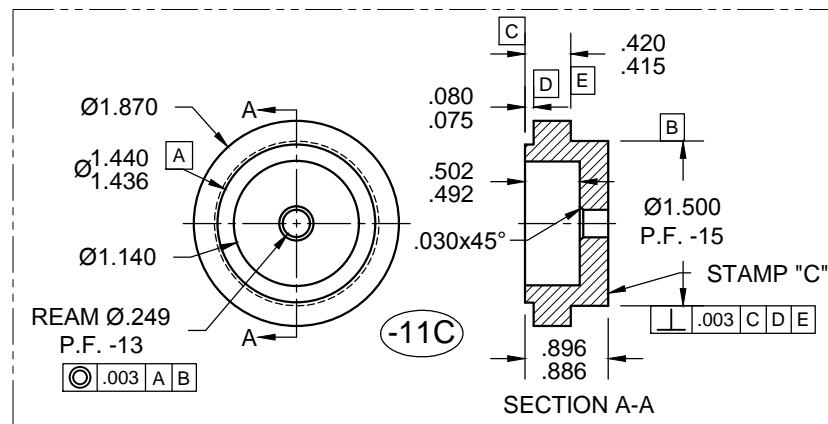
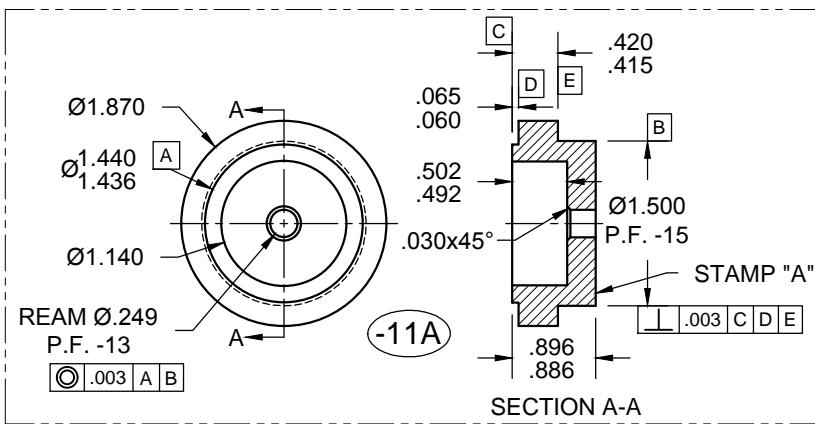
REV		DESCRIPTION		DATE	INITIAL	APPROVED
1B		ADDED MISSING DIM .63 & .97 -1, ADDED MISSING 8.500 -15. CH'D LIMIT DIMENSION .535-.505 TO .528 PER W.P.		5/5/10	RJC	RW



-15

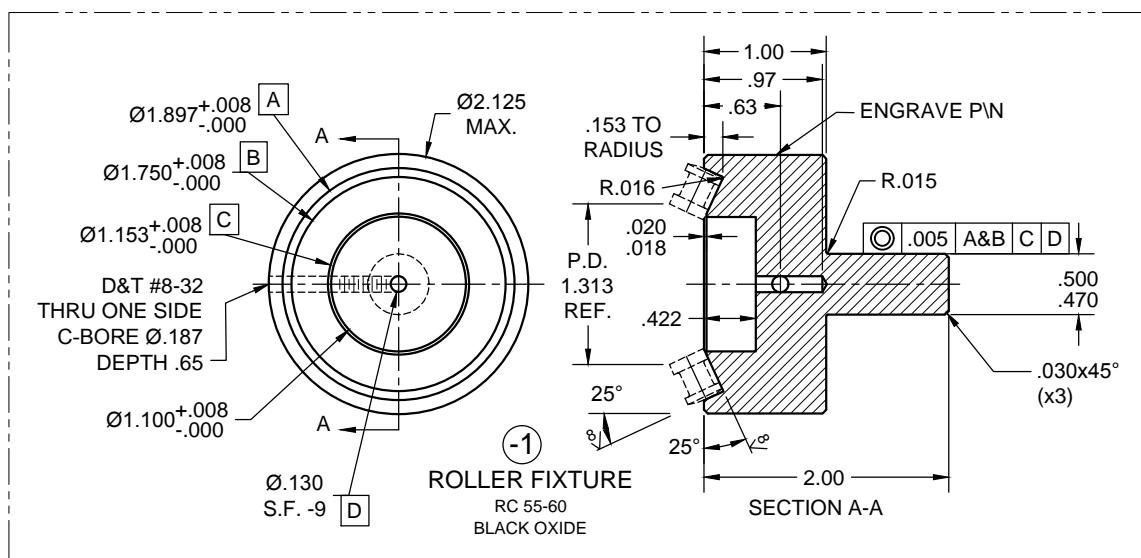
PLATE

RED BARN MACHINE	
TITLE	
FIXTURED SWAGING SYSTEM PLATE	
DWG NO.	REV 1B
DWG NO. RBST2087-15	
DRAWN BY: PERRITT	
APPROVED <i>D. Weil</i>	
HEAT TREAT	
FINISH SPEC BLACK OXIDE	
USED ON MODEL	
UNLESS OTHERWISE SPECIFIED	
DIMENSIONS ARE IN INCHES	
TOLERANCES ON:	
DECIMALS .XXX ± .005 FRACTIONS ± 1/32	
XX ± .01 ANGLES ± 5°	
X ± .1	
UNLESS OTHERWISE SPECIFIED	
1. BREAK ALL SHARP EDGES .015 x 45° PR. .015 R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 8-15-07
SHEET 4 of 4	



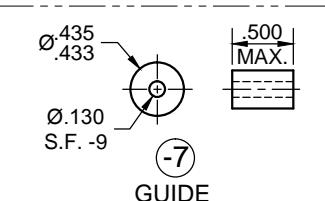
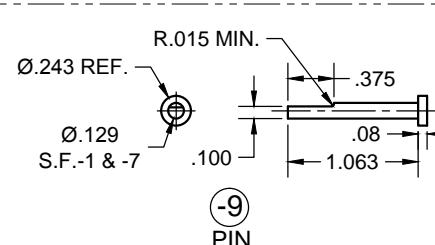
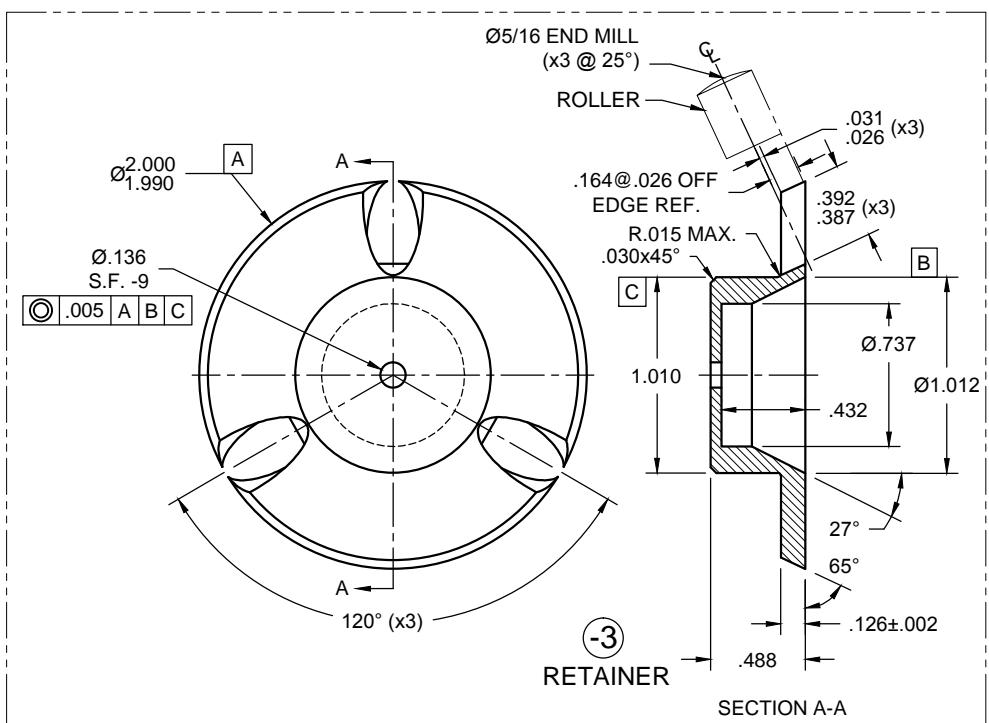
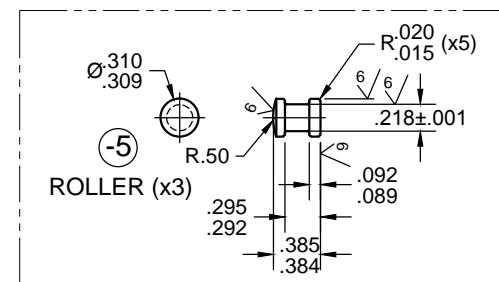
RB RED BARN MACHINE		REV 1B
TITLE		
FIXTURED SWAGING SYSTEM PARTS		
DWG NO. RBST2087-11 THRU -19		DRAWN BY: PERRITT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		
TOLERANCES ON: DECIMALS XXX ± .005 FRACTIONS ± 1/32 XX ± .01 ANGLES ± 5° X ± .1		
APPROVED HEAT TREAT FINISH SPEC BLACK OXIDE ALL USED ON MODEL		
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING		
SCALE NTS	DATE 4-2-08	SHEET 3 of 4

REV		DESCRIPTION		DATE	INITIAL	APPROVED
1		CHANGED -7 SLEEVE TO -7 GUIDE, ADDED RADIUS TO -9 & INCREASED -5 RADIUS FROM .015 MAX.		7/7/08	WP	DW
1B		ADDED MISSING DIM .63 & .97 -1, ADDED MISSING 8.500 -15. CH'D LIMIT DIMENSION .535-.505 TO .528 PER W.P.		5/5/10	RJC	RW

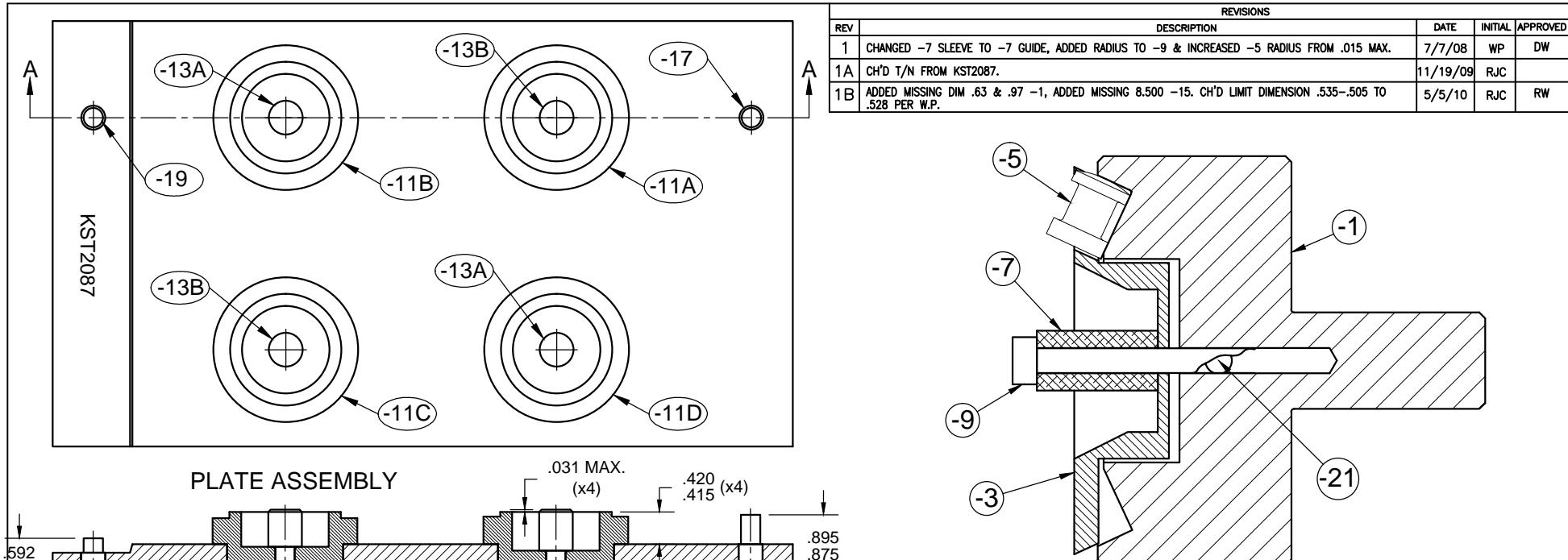


NOTES

- 1 ROLLER RACE SURFACES MUST HAVE SMOOTH APPEARANCE, FREE FROM MACHINING MARKS AND GROOVES.
- DO FIRST ARTICLE INSPECTION ON -1 ROLLER FIXTURE BEFORE HEAT TREATING.



TITLE		RED BARN MACHINE	
DWG NO.		FIXTURED SWAGING SYSTEM PARTS	
DWG NO.		REV 1B	
UNLESS OTHERWISE SPECIFIED		DRAWN BY: PERRITT	
DIMENSIONS ARE IN INCHES		APPROVED: D. Weil	
TOLERANCES ON:		HEAT TREAT SEE PART	
DECIMALS XXX ± .005		FINISH SPEC SEE PART	
XX ± .01		ANGLES ± .5°	
X ± .1		USED ON MODEL	
UNLESS OTHERWISE SPECIFIED			
1. BREAK ALL SHARP EDGES .015 x 45° PR.015 R			
2. DIMENSIONAL LIMITS APPLY AFTER PLATING			
SCALE	NTS	DATE	4-2-08
		SHEET 2 of 4	



ASSY QTY	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS	Pg.
W/O	-1	1	ROLLER FIXTURE	1	0-1 DRILL ROD	Ø2-1/8 x 2-1/8		2
	-3	1	RETAINER	1	BRONZE RND. BAR	Ø2 x 5/8		2
	-5	3	ROLLER	1	STEEL	.310 MINUS GAUGE PIN MSC #89031009		2
	-7	1	GUIDE	1	BRONZE RND. BAR	Ø1/2 x 5/8		2
	-9	1	PIN	1	STEEL	MCMASTER-CARR #98378A909		2
	-11A	1	SEAT	1	4140 RND. BAR	Ø1-7/8 x 1		3
	-11B	1	SEAT	1	4140 RND. BAR	Ø1-7/8 x 1		3
	-11C	1	SEAT	1	4140 RND. BAR	Ø1-7/8 x 1		3
	-11D	1	SEAT	1	4140 RND. BAR	Ø1-7/8 x 1		3
	-13A	2	LOCATING PIN	1	1018 RND. BAR	Ø1/2 x 7/8		3
	-13B	2	LOCATING PIN	1	1018 RND. BAR	Ø1/2 x 7/8		3
	-15	1	PLATE	1	4140 PLATE	1/2 x 5-1/2 x 9-5/8		4
	-17	1	PLATE PIN	1	1018 RND. BAR	Ø3/8 x 7/8		3
	-19	1	PLATE PIN	1	1018 RND. BAR	Ø3/8 x 3/4		3
B/O	-21	1	SOCKET HEAD SET SCREW	1	STEEL, BLACK	#8-32 x 1/4	N/S	

REVISIONS			
REV	DESCRIPTION	DATE	INITIAL APPROVED
1	CHANGED -7 SLEEVE TO -7 GUIDE, ADDED RADIUS TO -9 & INCREASED -5 RADIUS FROM .015 MAX.	7/7/08	WP DW
1A	CH'D T/N FROM KST2087.	11/19/09	RJC
1B	ADDED MISSING DIM .63 & .97 -1, ADDED MISSING 8.500 -15. CH'D LIMIT DIMENSION .535-.505 TO .528 PER W.P.	5/5/10	RJC RW

RB RED BARN MACHINE

TITLE
FIXTURED SWAGING SYSTEM

DWG NO. RBST2087 **REV** 1B

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS XXX ± .005 XX ± .01 X ± .1	DRAWN BY: PERRITT APPROVED D. Meil HEAT TREAT FINISH SPEC SEE PARTS PAGES USED ON BEARINGS
FRACTIONS ± 1/32 XX ± .01 X ± .1 ANGLES ± 5°	222-312-753-101
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR. .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	222-312-753-103

SCALE NTS **DATE** 4-2-08 **SHEET** 1 of 4

REVISIONS		
REV	DATE	INITIAL APPR
-	-	-

NOT APPROVED FOR PRODUCTION

ASSY QTY	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MAT.	B/O INFORMATION OR SPECIFICATIONS	Pg.	TITLE	---
			-1	1	RND	6061	Ø8-1/4 x 3-7/8	2	DWG NO.	RE
									UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS XXX ± .005 FRACTIONS ± 1/32 XX ± .01 ANGLES ± .5° X ± .1	DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH SPEC USED ON MODEL
									1. BREAK ALL SHARP EDGES .015 x 45° PR-.015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
ASSY #									SCALE NTS DATE 8-15-07 SHEET 1 of	

NOT APPROVED FOR PRODUCTION

REVISIONS			
REV	DESCRIPTION	DATE	APPROVED

PART #	QTY	DESCRIPTION
-1	1	--
DRAWN BY:	PERRITT	
CHECKED		
HEAT		
TREAT		
FINISH		
SPEC		
USED ON MODEL	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
?	TOLERANCES ON: DECIMALS .XXX ± .005 FRACTIONS ± 1/32 .XX ± .01 ANGLES ± 5° .X ± .1	
	UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES 0.015 x 45° PR. 0.015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
RB	RED BARN MACHINE	
TITLE		
DWG NO.		
SCALE	NTS	DATE 1-28-06
		SHEET 1 of 1

